

Work Order ID 62377

September 29, 2010 7:09:06 AM

Page 1

Item ID: D4203-051
Revision ID: PRELIM
Item Name: Pedal Lock Assembly

Accept

Setup Start

Stop

Start Date: 9/29/10 Start Qty: 1.00
Required Date: 10/04/10 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr	Revision Nbr
D4203	PAT See Rev. A

100 Pick Kit
Packaging
Packaging

0.00

0.00

110
Small Fab
Small Fab

Memo
1- assemble per dwg
2- FABRICATE D3370-S.

0.00

0.00

120
QC
Quality Control

QC5- Inspect part completeness to step on W/O
Memo

0.00

0.00

9/30/10

9/30/10/05

① 7/10/10/18

Work Order ID 62377

September 29, 2010 7:09:06 AM

Page 2

Item ID: D4203-051
Revision ID: PRELIM
Item Name: Pedal Lock Assembly

Accept

Setup Start

Stop

Start Date: 9/29/10 Start Qty: 1.00
Required Date: 10/04/10 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPG 3027

0.00

Packaging

per work SEN

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/14/08

10/10/18

MF

10-10-18

POSITIVE RECALL
EFFECTIVE 09.29 AUTH [Signature]
DASED [Signature] DATE 10.10.18

22519

Picklist Print

September 29, 2010 7:09:04 AM

Page 1
10

Work Order ID: 62377

Parent Item: D4203-051

Parent Item Name: Pedal Lock Assembly







Start Date: 9/29/10

Required Date: 10/04/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4203-1 		Manufactured	No			100	Each	0.0000	1	1			
Base													
D4203-3 		Manufactured	No			100	Each	0.0000	1	1			
Cover													
D3373-5P 		Purchased	No			100	Each	0.0000	1	1			
Cam Lock													
D3385-3 		Manufactured	No			100	Each	109.0000	1	1			
Hinge													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST054	109						
						22387	109						
AN526C832R6 		Purchased	No			100	Each	354.0000	4	4			
Screw													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST327	354						
						16612	354						
D3370-5 		Manufactured	No			100	Each	0.0000	1	1			
Cam													

B62350 (K)

B62351 (IX)

B 22 294

EP 10/10/05

EP 10/10/05

D EP 10/10/05

EP 10/10/05

EP 10/10/05

A MK

10-10-18

Picklist Print

September 29, 2010 7:09:05 AM

Page 2

Work Order ID: 62377

Parent Item: D4203-051

Parent Item Name: Pedal Lock Assembly



Start Date: 9/29/10

Required Date: 10/04/10

Start Qty: 1.00

Required Qty: 1.00

238-028

Purchased

No

100

Each

235.0000

2

2



3/16" Dowel Pin .5" long



Handwritten signature and date: 9/30/10/05
2

Location

Loc Qty

Loc Code

ST399

235

106673

92

108114

99

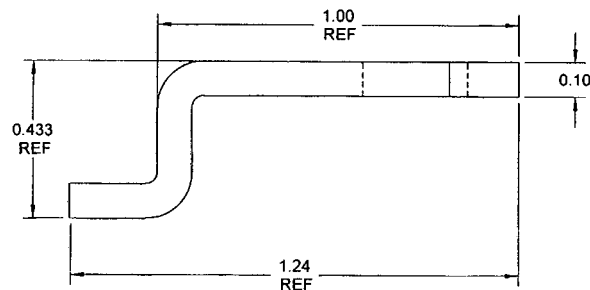
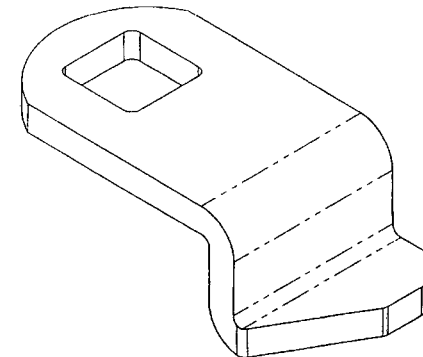
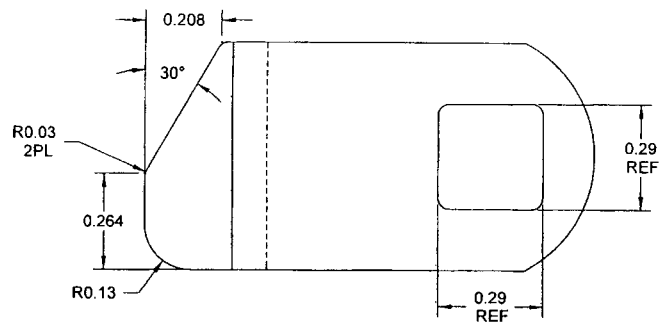
17848

44

September 29, 2010 7:09:05 AM

Shop Packet Print

Page 2



D3370-5 CAM

w/o 62377

RELEASED
7801-14

NOTES:

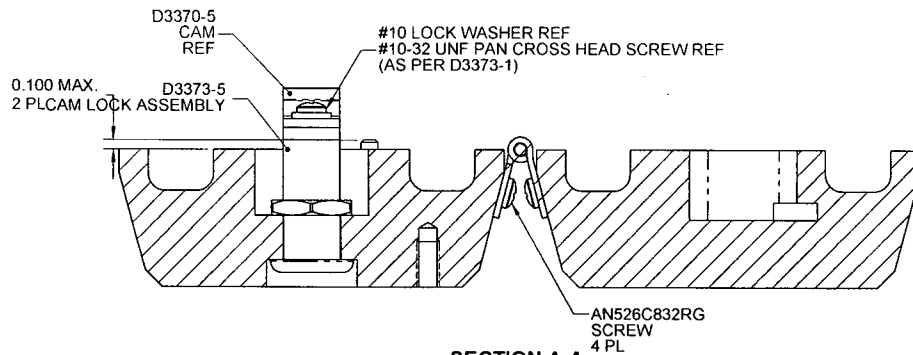
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	08.07.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

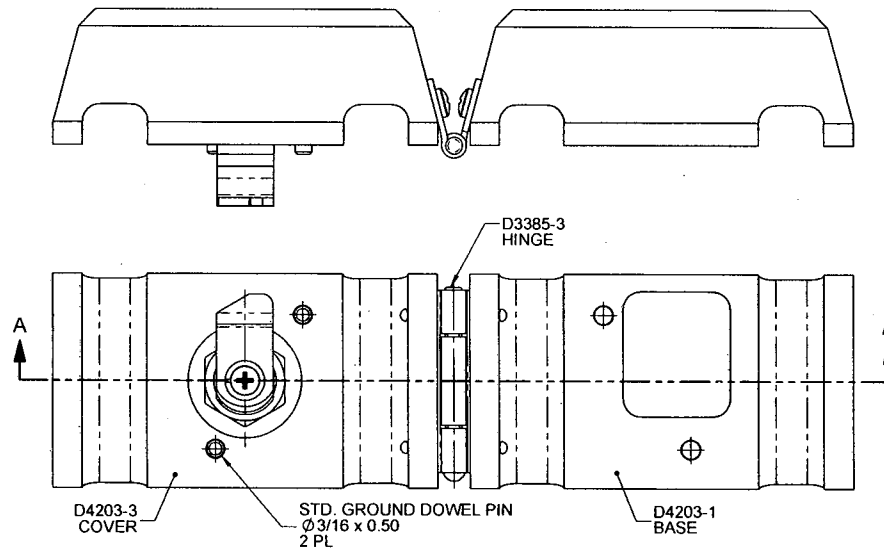
Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D4203-041	TAIL ROTOR DISABLING KIT
1	X	D4203-051	PEDAL LOCK
	1	D4203-1	BASE
	1	D4203-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW
	1	D3370-5b	

PRELIMINARY ISSUE
 10.09.24
 MP

A	NEW ISSUE		MP	10.09.27
REV.	DESCRIPTION		BY	DATE
DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	MP			
CHECKED		DRAWING NO.	REV. PA1	
MFG. APPR.		D4203	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		PEDAL LOCK	NTS	
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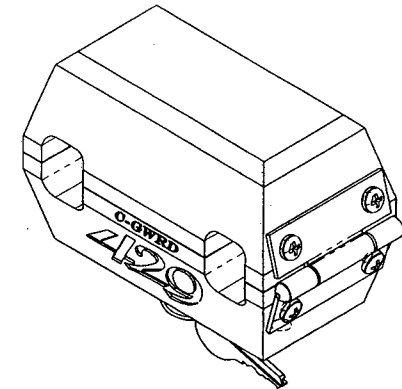


SECTION A-A



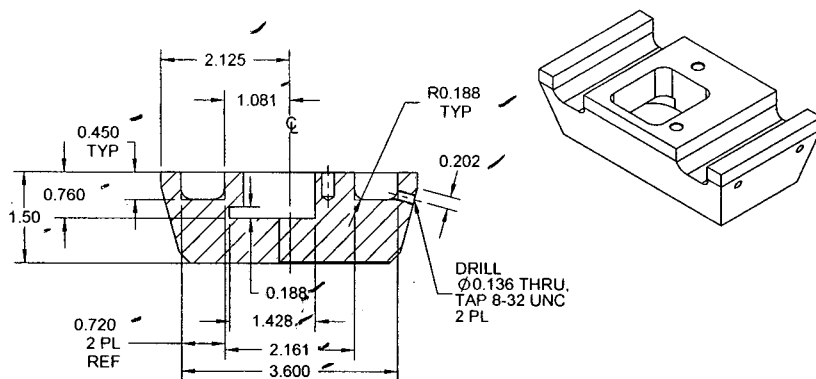
D4203-051 PEDAL LOCK ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

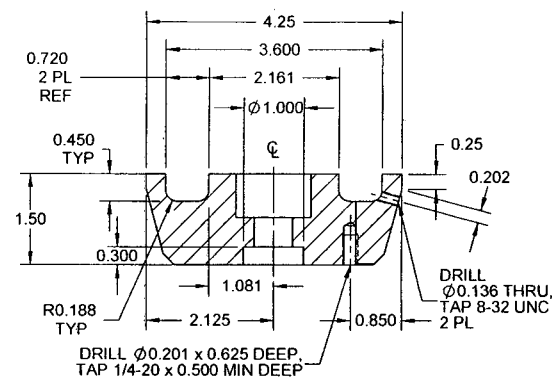


PRELIMINARY ISSUE
10.09.24
MP

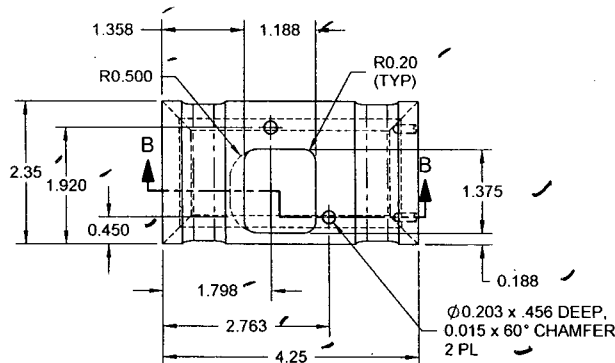
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DRAWN	MP		
CHECKED		DRAWING NO. D4203	REV. PA1
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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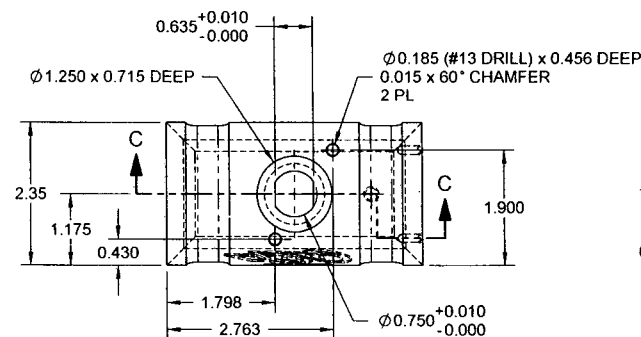
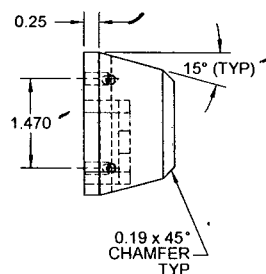
SECTION B-B



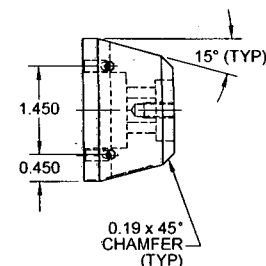
SECTION C-C



D42031 BASE



D4203-3 COVER



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) ENGRAVE LOGO AND AIRCRAFT ID PER D4203-3.SLDPRT

PRELIMINARY ISSUE
10.09.24
MP

DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED		DRAWING NO. D4203	REV. PA1
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
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Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D4203-041	TAIL ROTOR DISABLING KIT
1	X	D4203-051	PEDAL LOCK
	1	D4203-1	BASE
	1	D4203-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

62 377

RELEASED
2010-10-15
MP

A	NEW ISSUE	MP	10.10.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MP	DART AEROSPACE LTD	
DRAWN	MP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4203	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	10.10.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

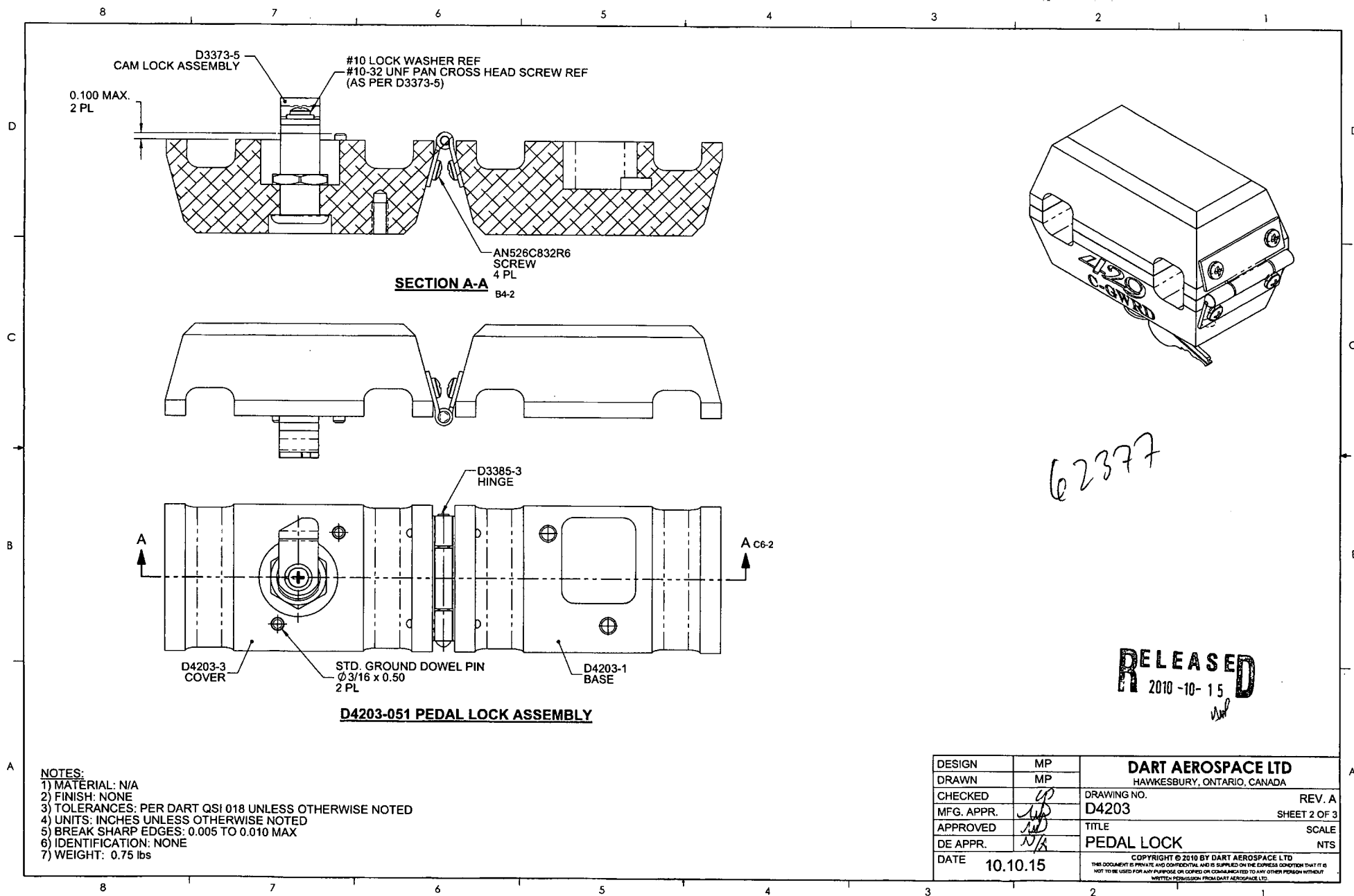
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



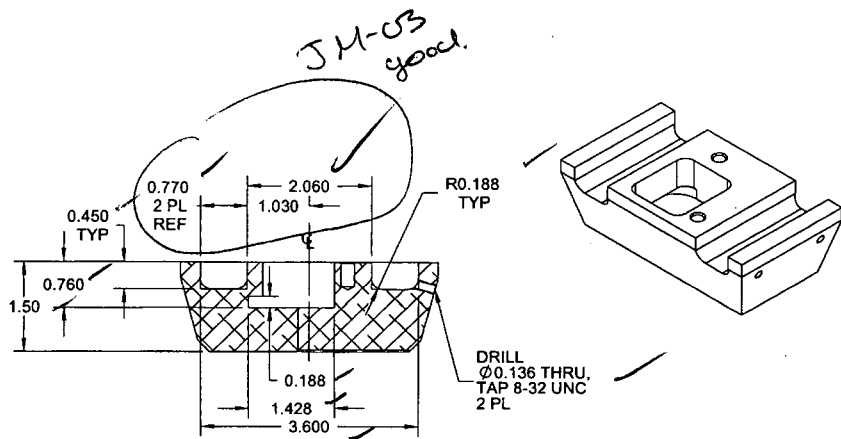
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

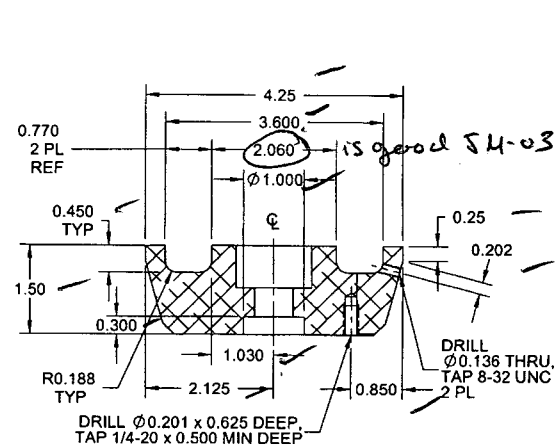
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

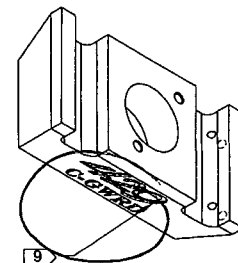
NOTE: Date & initial all entries



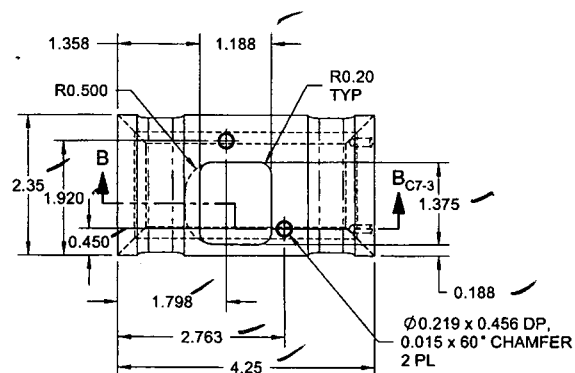
SECTION B-B B6-3



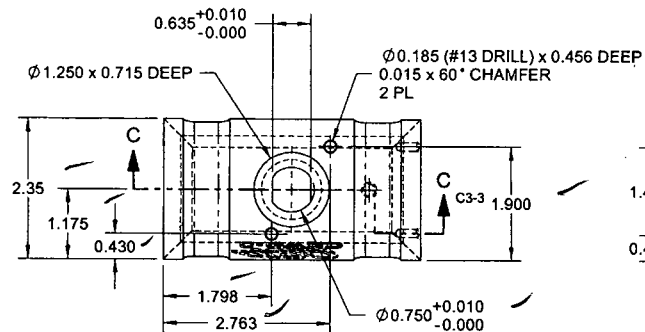
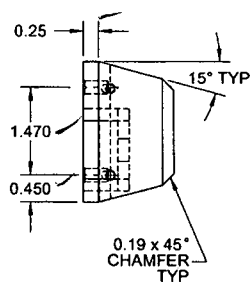
SECTION C-C B2-3



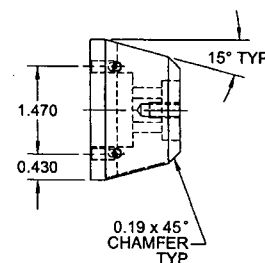
62377



D4203-1 BASE



D4203-3 COVER



NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH
- 9) ENGRAVE LOGO AND AIRCRAFT ID PER D4203-3.SLDPRT

RELEASED
2010-10-15

DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	MP	D4203	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	PEDAL LOCK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries